

All-Position, Tubular Hardfacing Electrode Combats Fine Partical Abrasion,
2-Body Abrasion and Light Impact

EutecTrode® 7030



WELDING

- Designed for maximum efficiency and productivity
- Maintains high temperature hardness to 1000°F
- Moisture-resistant coating



DESCRIPTION:

EutecTrode 7030 is specifically formulated to resist fine particle erosion, 2-body abrasion and light impact while maintaining deposit hardness up to 1000°F. This all-position, tubular electrode has a high deposition rate for increased efficiency, productivity, coverage and usability. When used at low amperage, dilution is minimized and the key wear resistant properties are maintained. EutecTrode 7030 possesses built-in moisture resistance.

TYPICAL APPLICATIONS:

Applications

- Ripper Shanks
- Impeller Bars
- Stripper Bars
- Grizzly Bars
- Drag Chain Links
- Cement Chutes
- Clinker Belt Links
- Skip Car Lips
- Discharge Chutes
- Cone Crusher Rolls

Industry

- Quarrying
- Mining / Quarrying
- Quarrying
- Cement Works
- Mining
- Cement Works
- Cement Works
- Deep Mining
- Cement Works / Quarrying
- Quarrying

TECHNICAL DATA:

Hardness As-Deposited:	HRC: 55 - 60
Typical Temperature Range:	1000°F
Carbide Content:	Medium to High
Carbide Hardness:	1100 - 1200 VPN (M ₇ C ₃) (M = Cr-W-Cb-Mo)
Current & Polarity:	AC or DCEP/N (+/-)

Availability and Recommended Amperages

Dia.	3/8" 9.0mm	1/2" 12.7mm
Amp.	130-190	200-430

WELDING PARAMETERS:

Preparation: Clean weld area of scale and/or oxide. A nominal preheat of 150°F is advised if the part is below 40°F or over 1" thick. For higher carbon steels higher preheats will be needed.

Note: Do not preheat Hadfield manganese steel castings above 400°F as this will cause time-temperature embrittlement.

Technique: Maintain a medium-to-short arc and incline the electrode at a 45° angle in the direction of travel. Excessive weaving (more than 2x the electrode diameter) is not advised as wide beads can cause excessive base metal overheating and degrade the weld deposit wear properties. Back whip craters to reduce crater-cracking tendencies.

Do not deposit more than two layers.

Post-Welding: Allow parts to slow cool in still air. High carbon steels and air hardenable steels should be covered with a heat-retardant blanket.

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